

Date: Tuesday, 06/01/2009 10:04:28 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : LUG ASSEMBLY
<b>Job Number</b> : 44393	
<b>Estimate Number</b> : 10011	
<b>P.O. Number</b> :	<b>Part Number</b> : D27361
<b>This Issue</b> : 06/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2736 REVA
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : // <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 43853	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 12/01/2009 <b>Qty:</b> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.01.06</u>	
<b>Comment</b> : Est Rev:D Removed from 9 digit 05-10-25 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2591	Lug, GHW Adapter
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2591	Lug	B39864

EL 9-1-22 x6

2.0	D27351	Lug Bracket
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2735-1	Lug Bracket	B39819

EL 9-1-22 x6

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

Weld D2591 &amp; D2735-1 as per QSI 004 and Dwg D2736 using locating Jig DT8484

Steel Rod Batch: 11108350

EL 9-1-21 x6

4.0	QC9	VISUAL WELDING INSPECTION
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**Comment:** VISUAL WELDING INSPECTION

PD 09-01-21 (6)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

S 09/01/01 (46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 06/01/2009 10:04:28 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 44393

Part Number: D27361

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



m109996



Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

(6)

START TIME:

1:25

OVEN TEMPERATURE:

400°

FINISH TIME:

1:55

FL 09/01/26

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-26

46

8.0

PACKAGING 1

PACKAGING RESOURCE #1



6X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 476

9/1/27

50

9.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/28

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



11.09.06.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

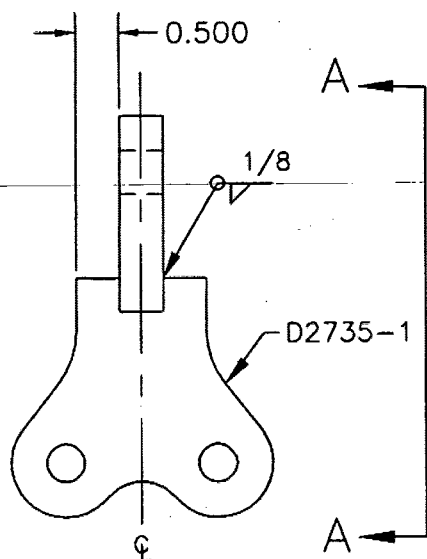
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

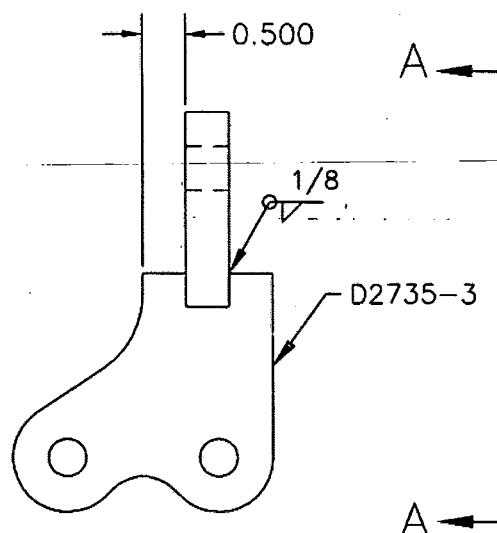
**NOTE:** Date & initial all entries



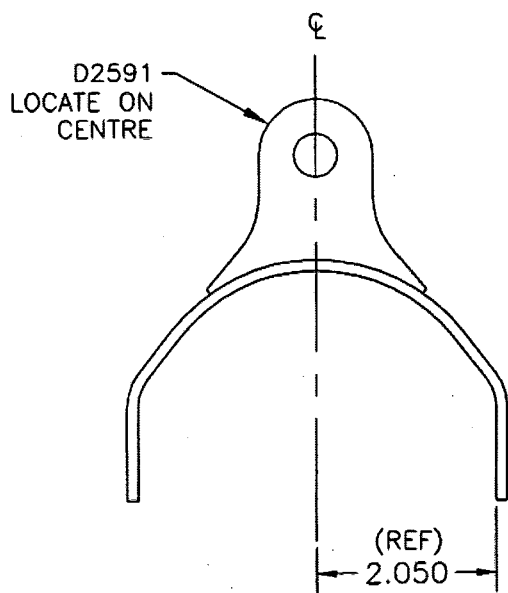
DESIGN <i>DMY</i>	DRAWN BY <i>DMY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>CA</i>	DRAWING NO. D2736	REV. A SHEET 1 OF 1
DATE 97.12.18		TITLE LUG ASSEMBLY	SCALE NTS
A	97.12.18	NEW ISSUE	



D2736-1 LUG ASSEMBLY



D2736-3 LUG ASSEMBLY



VIEW A-A

NOTES:

WELD PER DART QSI 004

FINISH: POWDER COAT WHITE PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

PART IS SYMMETRIC ABOUT CENTRE-LINES (CL)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 44393

**RELEASED**  
97/12/24 DS

ECN 057